



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3624-2

Job Sheet 175570



Part No: D3624-2

Job Qty: 4 ea

Part Name: Bubble Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/25/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV D IPP A Thermoform in house 6/27/2007 DL IPP B. Revised due to corrupt operating Program.
7/23/2007 DL IPP C. Dwg. Rev. change 7/30/2007 IPP D. Dwg. Rev. Updated 4/25/2008 verified by:DD

Ship Via:

REVISED QTY

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs		4/25/18	0.00	0.00	Purchasing		AP 18/09/24
140	Packaging	4 pcs		4/25/18	0.00	0.00	Packaging2		AP 18/09/24
150	QC	4 pcs		4/25/18	0.00	0.00	QC6		10-04-24
170	Packaging	4 pcs		4/25/18	0.00	0.00	Packaging3-1		6
180	QC21-SA	4 Ea		4/25/18	0.00	0.00	QC21		18/01/25 APR 25 2018 9-89

Part Op 110 - ISSUE P/O: 39554 SUPPLIER:PLASTECB MANUFACTURE D3624-2 AS PER DWG C OF C
Descriptions: IS REQUIRED

DAS 21 APR 24 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3624-2P	Bubble Window	4 pcs (1 ea)	110-Purchasing	506467
MACRYLICS.177	0.177" Plexiglas G Clear Cast Acrylic Sheet	64 sf (16 ea)	110-Purchasing	1064361

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3624-2P	4	0	0
	MACRYLICS.177	64	1,843	0

Part Specifications

Specifications could not be found.

Plex 4/19/18 11:44 AM dart.lavoie.chantal



Container No: **S064364**



Bubble Window

PART NO: **D3624-2**

Serial No/Batch: **S064364**

Revision:

Operation:

Change No:

Packaging

Mfg Date: 04/24/18

Job No: 175570

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039554**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO039554

PO Date: 4/10/18

Due Date: 5/10/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

REVISED QTY

E-MAILED
APR 19 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D4942-1P			Floor Protector AS PER DWG D4942 REV. D receive pcs	Firmed	5/8/18	5 Ea	0 Ea	5 Ea	\$100.00/Ea	\$500.00
Line Item Note job no. 175636											
2	D3624-2P			Bubble Window As Per Dwg D3624 Rev. D	Firmed	4/20/18	4 pcs	0 pcs	4 pcs	\$300.00/pcs	\$1,200.00
Line Item Note JOB NO. 175570											
3	D3290-3P			Window As Per Dwg D3290 Rev. C	Firmed	5/8/18	8 Ea	0 Ea	8 Ea	\$45.00/Ea	\$360.00
Line Item Note job no. 175702											
Grand Total:											\$2,060.00

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Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 39554 SO # 023053

Part #	<u>D3624-2</u>	Qty.	<u>2</u>	Batch #	<u>-002</u>
Description	<u>BUBBLE WINDOW (A119)</u>	Material usage	<u>1 SHEET</u>	Lot#	<u>245119</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: 
(Approved QA Signatory)

Date: APRIL 20, 2018 C O F C # 059

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. # VERBAL -
REPLACEMENT

SO # 022988

Part #	<u>D3624-2</u>	Qty.	<u>2</u>	Batch #	<u>-001</u>
Description	<u>BUBBLE WINDOW (A119)</u>	Material usage	<u>1 SHEET</u>	Lot#	<u>245119</u>
					<u>DAS 9 9-89</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AB

(Approved QA Signatory)

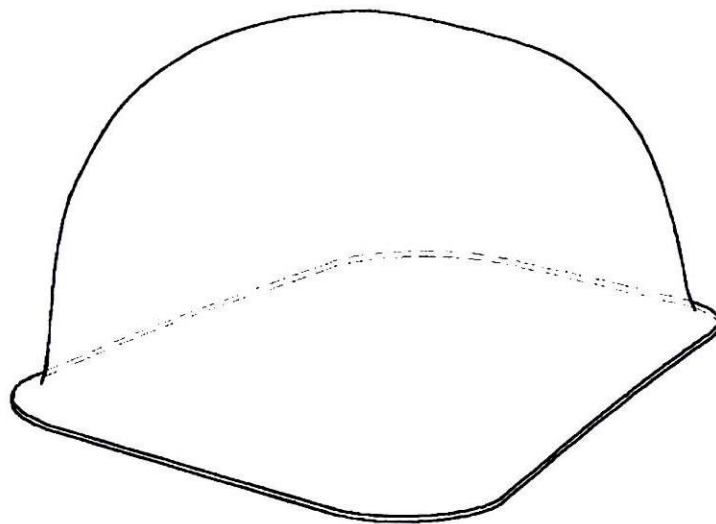
Date: APRIL 20, 2018

C OF C # 058

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plastechnonline.com, Web: www.plastechnonline.com



D3624-2 BUBBLE WINDOW

NOTES:

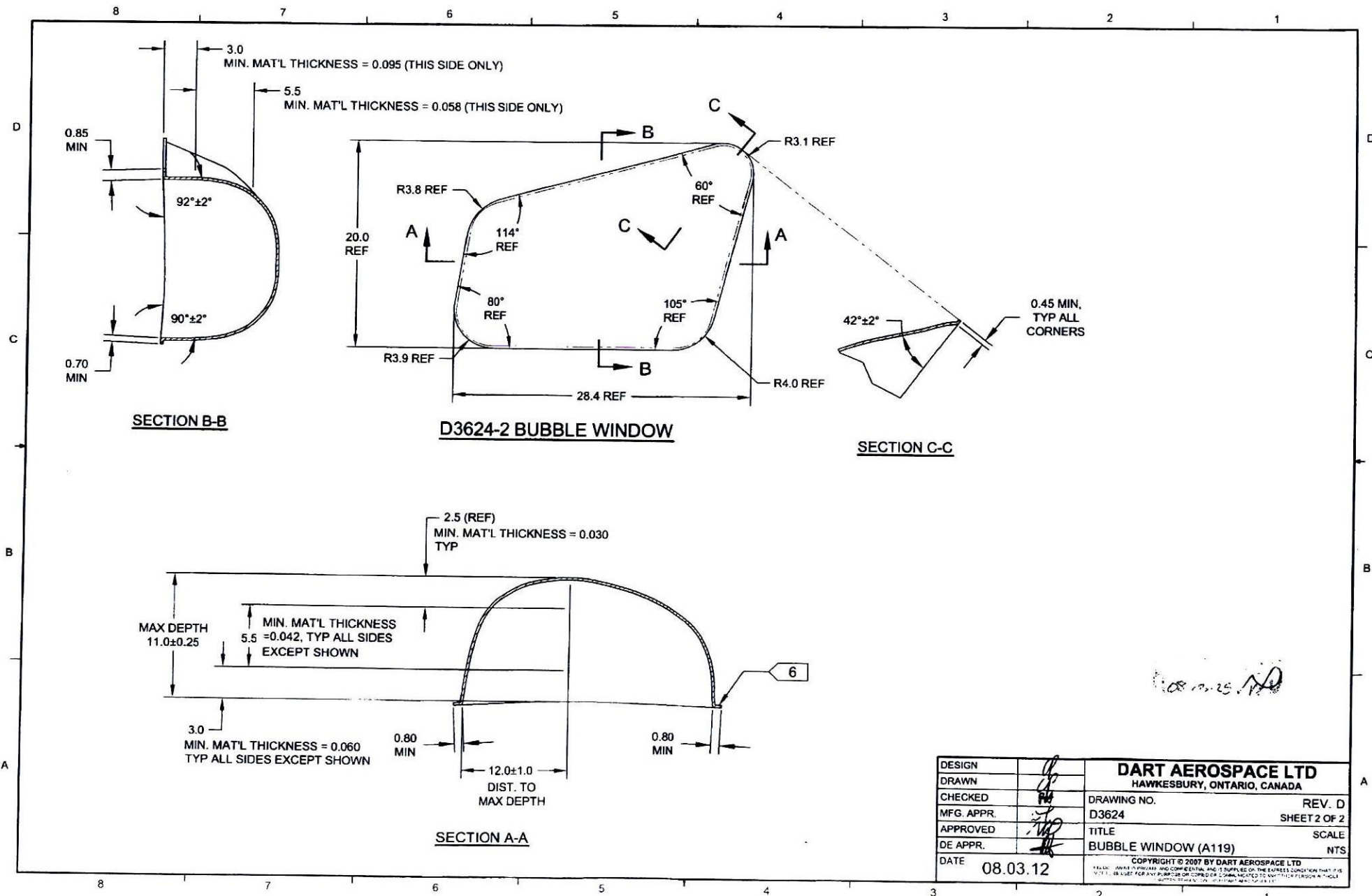
- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
0.177 TO 0.188 THICK (STOCK, REF DART SPEC M-ACRYLIC-S)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".
 - 7) WEIGHT: 2.95 lbs
 - 8) FORM PER DT8953 AND QSI 022
- FORMING PROCESS: (a) DRAPE OVER DT8953 MOLD
(b) HEAT TO 290°F
(c) VACUUM FORM TO SPECIFIED HEIGHT
(d) LET COOL TO AT LEAST 100°F BEFORE HANDLING
(e) TRIM FLANGE USING DT8954

REV.	DESCRIPTION	BY	DATE
D	REDRAW, REFORMAT. RMV SHAPE TOOL, ADD SEC B-B (2C8) & C-C (2C3), ADD FLANGE & WALL & WALL ANGLE DIMS. UPDATE MATL SPEC (1B8)	CP	08.03.12
C	ADD TOOL TO CONTROL BUBBLE SHAPE	CP	07.06.27
B	11.0" DEPTH WAS 12.0"	CP	07.05.24
A	NEW ISSUE	CP	07.06.27

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3624 TITLE BUBBLE WINDOW (A119) SCALE NTS DATE 08.03.12
DRAWN		
CHECKED		
MFG. APPR.		
DE APPR.		

REV. D SHEET 1 OF 2

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106
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DART AEROSPACE LTD		Work Order:	
Description: Bubble Window (A119)		Part Number:	D3624-2
Inspection Dwg: D3624	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Bubble Depth within tolerance	✓			
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	N/A			

Measured by: PD Date: 18.04.24

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.0	+/-0.25	11.0"				
3.0	0.095 Min	106"				
8.5	0.058 Min	80"				
3.0	0.060 Min	106"				
8.5	0.042 Min	80"				
2.5	0.030 Min	41"				
92°	+/-0.2° Min	92°				
90°	+/-0.2° Min	90°				
0.85	Min	85"				
0.70	Min	70"				

Measured by: PD 18.04.24 Date: 18.04.24

Audited by: [Signature] 18.04.24 Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	[Signature]

DART AEROSPACE LTD		Work Order:	
Description: Bubble Window (A119)		Part Number:	D3624-2
Inspection Dwg: D3624	Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Bubble Depth within tolerance	✓			
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	N/A			

Measured by: PD	Date: 18.04.24
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.0	+/-0.25	10.75				
3.0	0.095 Min	107"				
8.5	0.058 Min	.71"				
3.0	0.060 Min	106				
8.5	0.042 Min	.71"				
2.5	0.030 Min	.41"				
92°	+/-0.2° Min					
90°	+/-0.2° Min					
0.85	Min	.85"				
0.70	Min	.70"				

Measured by: PD	Date: 18.04.24
Audited by: [Signature]	Date: 18.04.24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL [Signature]	[Signature]

DART AEROSPACE LTD		Work Order:	
Description: Bubble Window (A119)		Part Number:	D3624-2
Inspection Dwg: D3624 Rev: D			Page 1 of 1

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☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Bubble Depth within tolerance				
Shape Definition				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.0	+/-0.25					
3.0	0.095 Min					
8.5	0.058 Min					
3.0	0.060 Min					
8.5	0.042 Min					
2.5	0.030 Min					
92°	+/-0. 2° Min					
90°	+/-0.2° Min					
0.85	Min					
0.70	Min					

Measured by:		Date:	
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Audited by:		Date:	
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Prototype Approval:		Date:	
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DART AEROSPACE LTD		Work Order:	
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Inspection Dwg: D3624	Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

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Description	Accept	Reject	Method of Inspection	Comments
Bubble Depth within tolerance				
Shape Definition				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.0	+/-0.25					
3.0	0.095 Min					
8.5	0.058 Min					
3.0	0.060 Min					
8.5	0.042 Min					
2.5	0.030 Min					
92°	+/-0.2° Min					
90°	+/-0.2° Min					
0.85	Min					
0.70	Min					

Measured by:		Date:	
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Audited by:		Date:	
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